

Order ID 108661

10-28-13 8:48:00 AM

108661

Page 1

Item ID: 647.9702

Revision ID:

Item Name: Upper Cutter Sub Assembly

Start Date: 10/28/13 Start Qty: 10.00

Required Date: 10/29/13 Req'd Qty: 10.00

Reference: use for lean training

Approvals: Process Plan: W Date: _____

QC: _____ Date: _____

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

647.9700

A1

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

120

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: _____

exp. date: _____

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

DAS
33 13-10-29
9-89

Work Order ID 108661

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Page 2

Item ID: 647.9702

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Start Date: 10/28/13 Start Qty: 10.00

Required Date: 10/29/13 Req'd Qty: 10.00

Reference: use for lean training

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER IAW MPP-120

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

① 14-03-20
closed at zero

Picklist Print

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Page 1

Work Order ID: 108661

Parent Item: 647.9702

Parent Item Name: Upper Cutter Sub Assembly

Start Date: 10/28/13

Required Date: 10/29/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 13-03-21 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.9711 Upper Body		Manufactured	No				Each	20.0000		92973 20		DAS 33 9/89	
10 Rework													
				<u>Location</u>		<u>Loc Qty</u>							
				MF		20							
				100355		15							
				90922		5							
MS27039-08-19 Screw		Purchased	No				Each	1,972.0000		60		DAS 33 9-89	
				<u>Location</u>		<u>Loc Qty</u>							
				ST307		89							
				123525		89							
				ST308		40							
				m126474		40							
				ST309		643							
				125654		643							
				st510		1200				125654			
				124309		1200							
NAS1149FN832P Washer		Purchased	No				Each	14,256.000		120		DAS 33 9-89	
				<u>Location</u>		<u>Loc Qty</u>							
				ST294		4280							
				123522		398							
				123900		3882				123900			
				ST510a		9976							
				125268		9976							

13-10-29

Picklist Print

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Page 2

Work Order ID: 108661

Parent Item: 647.9702

Parent Item Name: Upper Cutter Sub Assembly

Start Date: 10/28/13

Required Date: 10/29/13

Start Qty: 10.00

Required Qty: 10.00

MS21042L08

OK

Purchased

No

Each

2,496.0000

60

DAS

33

9-89

Nut

Location

Loc Qty

Loc Code

ST315

496

122141

3

122452

9

122814

377

123900

107

ST505

2000

125445

2000

122814

646.9711

Manufactured

No

Each

235.0000

Blade

Location

Loc Qty

Loc Code

CA

234

100268

97

102756

60

98911

77

ST437

1

91807

1

98973²⁰

DAS

33

9-89

13-10-29

102756

17

3

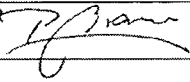
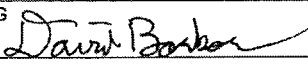
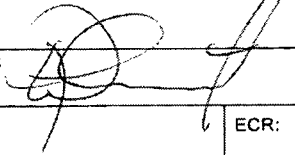

12 RETURN

8 REWOLD

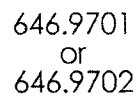
October-28-13 8:47:59 AM

Shop Packet Print

Page 2

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 04039					SHEET 1 OF 1	
	DWG NO. 646.9700		REV: B	PREPARED BY D. PETERS	DATE: 08/09/13		EFFECT ON DWG <input checked="" type="checkbox"/> INC. <input type="checkbox"/> UNINC.
	DWG TITLE: CUTTER SUB ASSY						
	APPROVED BY: ENGR 		MFG 	QC 	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: MARKED INSPECTION DIMENSIONS					ECR: NONE	
							
DOCUMENTS EFFECTED: <input type="checkbox"/> RFMS <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input type="checkbox"/> ICA <input type="checkbox"/> BOM				CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR		DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	

REVISION			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PREPARED REVISION: P02		N/A
N/A	DRAWN: KIRIAN	05/02/00	P. BRANCO
A	RE-CORPORATED ECH 00246, 00636, 03917	05/05/03	P. BRANCO
B	RE-CORPORATED ECH 00246	07/05/03	P. BRANCO
C	RE-CORPORATED ECH 00246	08/05/03	P. BRANCO



① MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12

② FINISH: HARD ANODIZE 1AW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER;
PRIME 1AW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX

③ MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS

④ FINISH: PRIME 1AW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX

5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED

6. IDENTIFY 1AW MPP-120

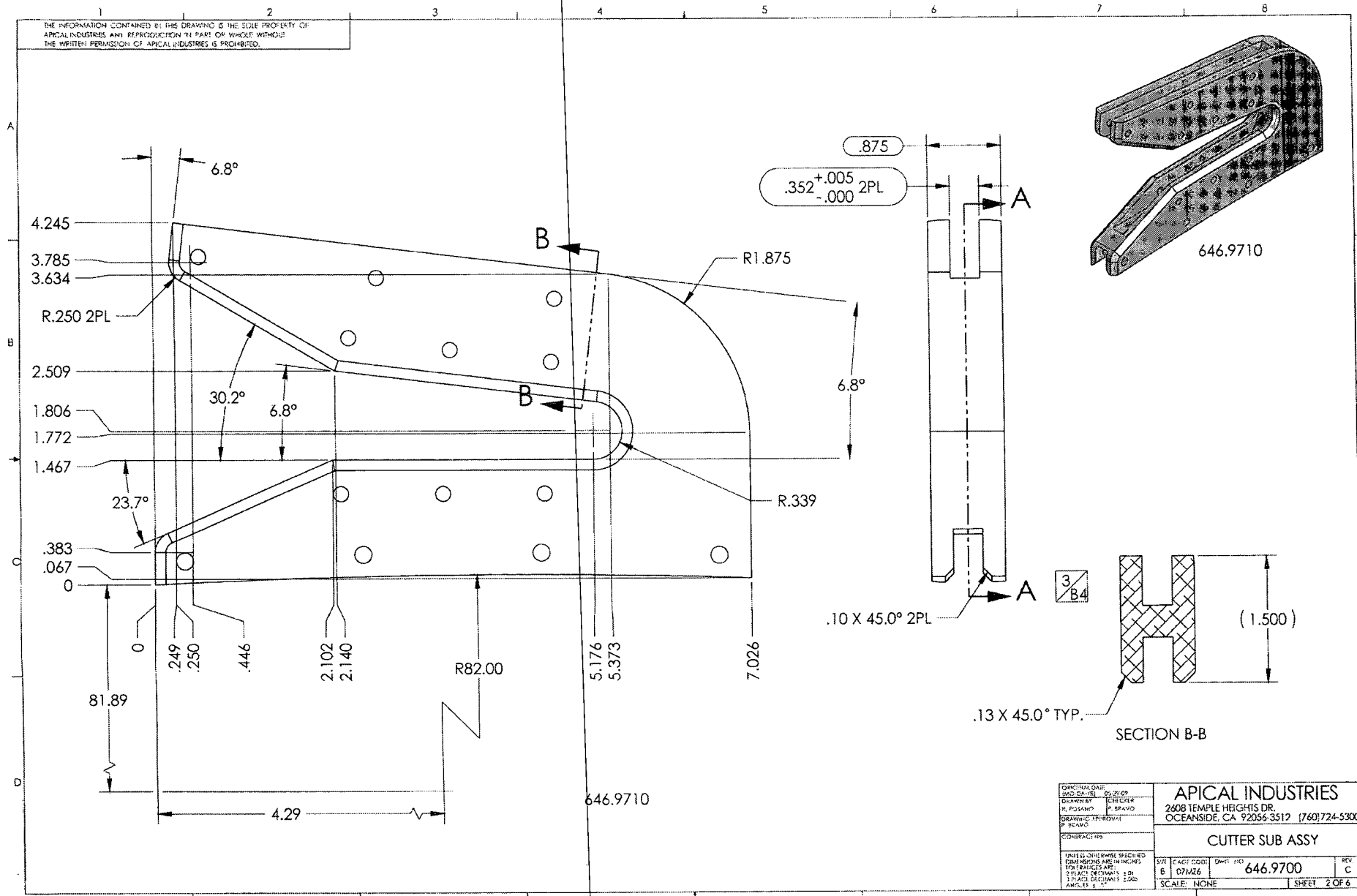
⑦ APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY

⑧ CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE

⑨ ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.

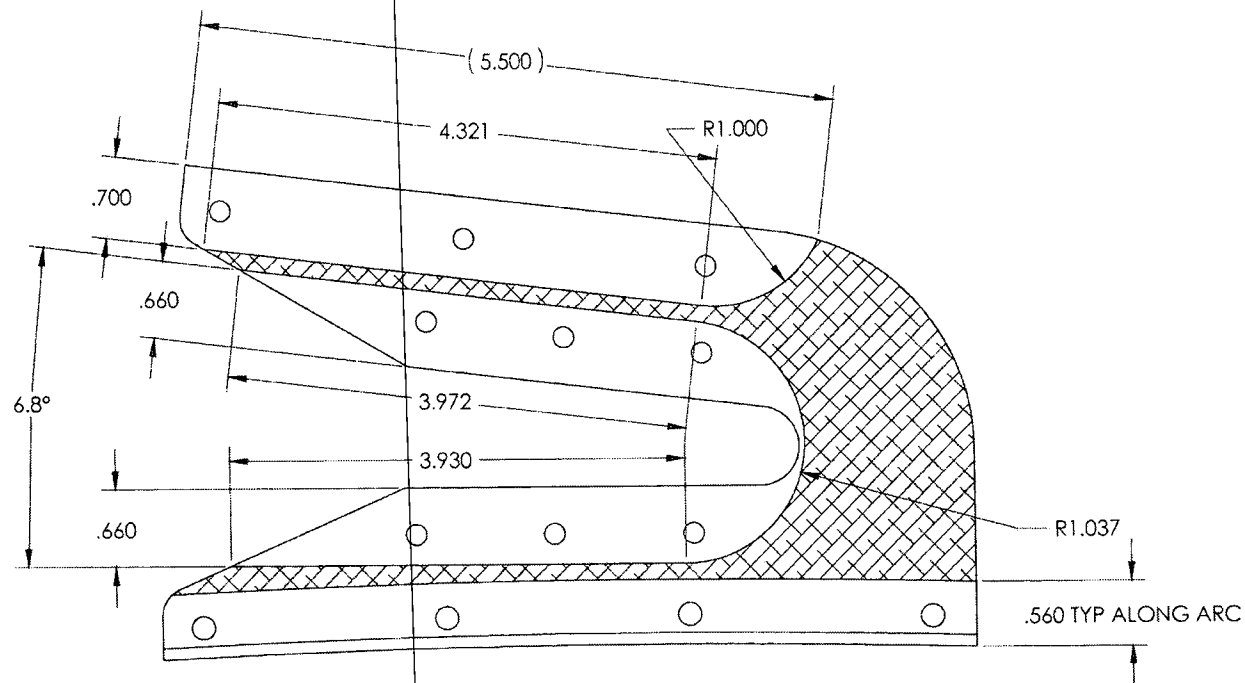
[illegible]

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ORIGINAL DATE: 1980-04-18		APICAL INDUSTRIES	
DRAWN BY: N. POSANO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: P. SPAYO		OCEANSIDE, CA 92055-3512 (760) 724-5300	
DRAWING TITLE: CUTTER SUB ASSY		CUTTER SUB ASSY	
CONTRACT NO:		646.9700	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. FOR FRANCES ARE 1/16" THICK. DIMENSIONS 1/16" AND 1/32" DECIMALS 1/16" AND 1/32" ANGLES 5°		SCALE: NONE	SHEET 2 OF 6

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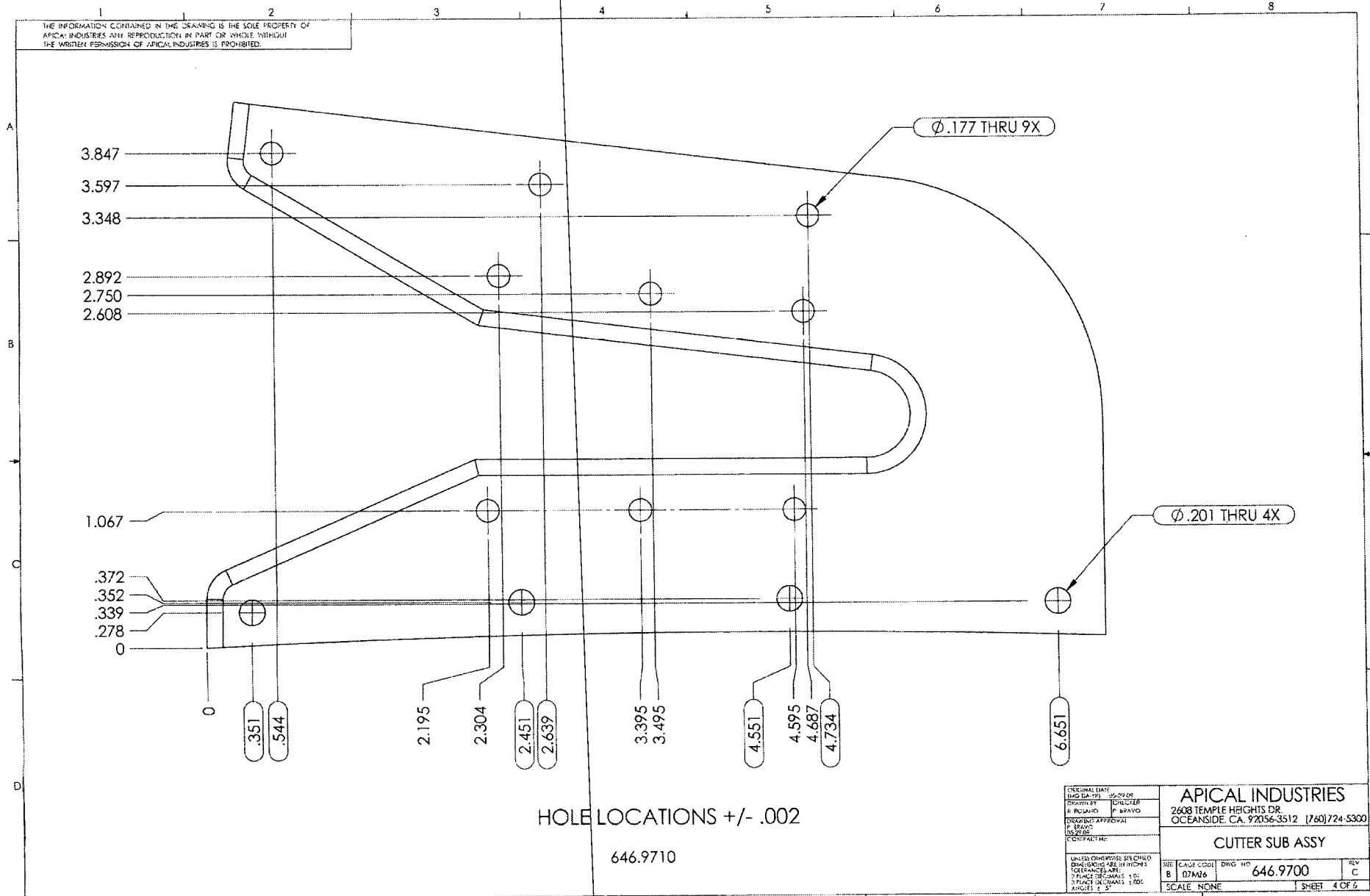


SECTION A-A $\frac{2}{C6}$

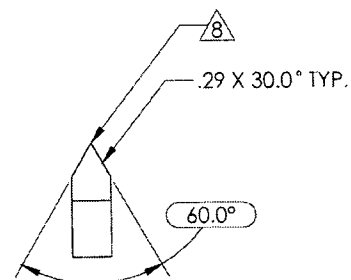
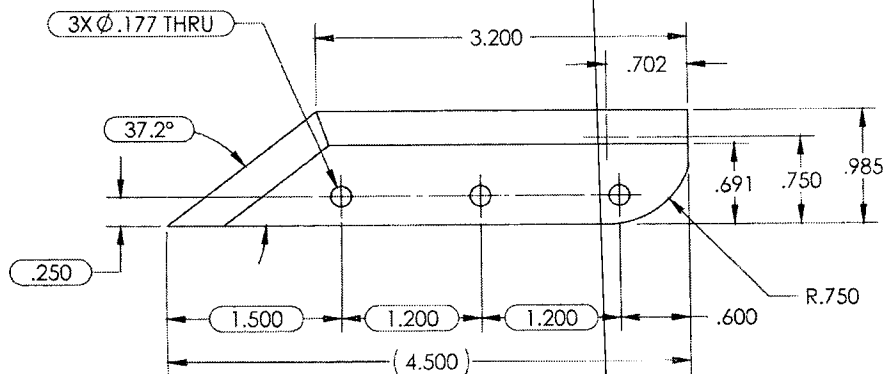
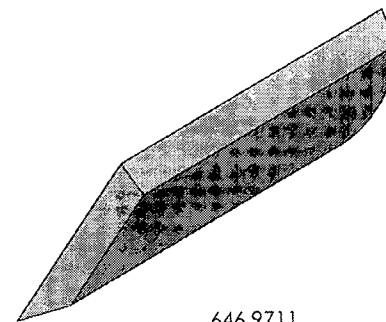
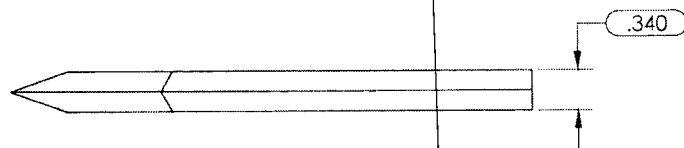
646.9710

APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 774-5300	
CUTTER SUB ASSY	
DATE: 02-28-99 DRAWN BY: P. STAVI CHECKED BY: P. STAVI DESIGNED BY: P. STAVI APPROVED BY: P. STAVI CONTRACT NO.:	SHEET: 3 OF 6
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES DECIMALS ARE: 3 PLACE DECIMALS ± .005 FRACTIONS ARE: 1/16 ± .001	SCALE: NONE

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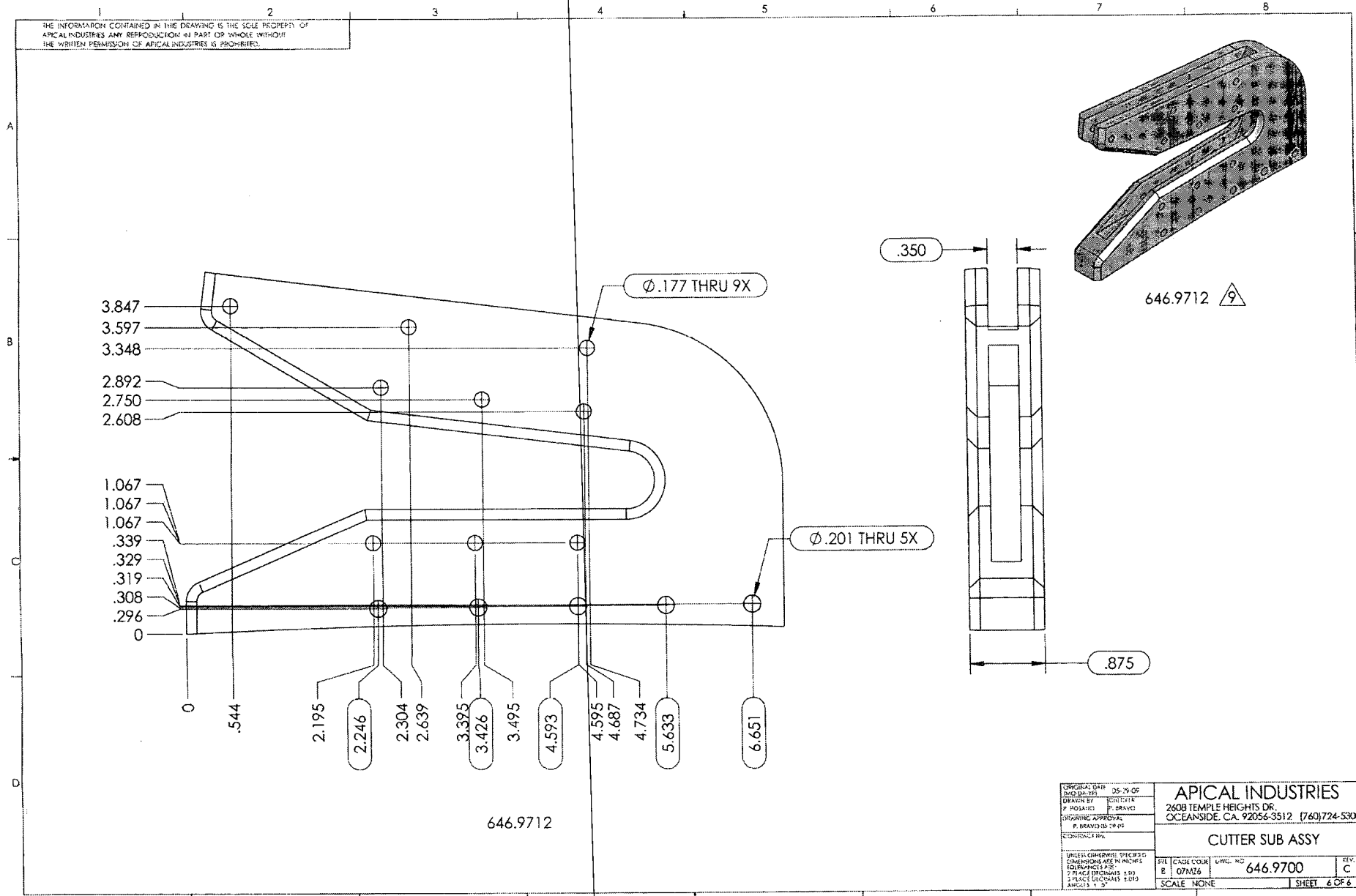
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646.9711

DRAWING DATE: 01-29-00		APICAL INDUSTRIES	
DRAWN BY: J. ROY	CHECKED: J. ROY	2608 TEMPLE HEIGHTS DR.	
BY: J. ROY	BY: J. ROY	OCEANSIDE, CA 92056-3512 (760) 724-5300	
DRAWING APPROVAL:	BY: J. ROY	CUTTER SUB ASSY	
DATE: 01-29-00	CONTRACT NO.:	646.9700	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES.		REV: B	REV: C
TOLERANCES ARE:		SCALE: NONE	SHEET 5 OF 6
FRACTIONS: 1/16, 1/8, 1/4, 1/2, 3/4, 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100			

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ORIGINAL DATE: 05-29-06		APICAL INDUSTRIES	
DRAWN BY: P. POSAHET	DESIGNED BY: P. POSAHET	2608 TEMPLE HEIGHTS DR.	
CHECKED BY: P. POSAHET	APPROVED BY: P. BRAYTON	OCEANSIDE, CA 92056-5512 (760)724-5300	
CUSTOMER: F.M.		CUTTER SUB ASSY	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES.	SHEET NO: 07/026	646.9700	REV: C
TOLERANCES ARE:	SCALE: NONE	SHEET 6 OF 6	
2 PLACE DECIMALS ±.010			
ANGLES: 1/2°			

